

Date: Thursday, 6/15/2006 1:51:27 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT ASSEMBLY  
 Job Number : 27593  
 Estimate Number : 10464  
 P.O. Number : N/A Part Number : D3278041  
 This Issue : 6/15/2006 S.O. No. : N/A Drawing Number : D3278 REV. B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : B  
 Previous Run : 24568 Material : N/A  
 Written By : *See comment below* Due Date : 7/5/2006 Qty: 30 Um: Each  
 Checked & Approved By : *06.06.15*  
 Comment : Est:A 04.04.19 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	27593A	SUPPORT



Comment: Sub-Component SUPPORT

2.0	27593B	SUPPORT
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Comment: Sub-Component SUPPORT

3.0	D32781	SUPPORT
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Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

SUPPORT

Pick:

Qty	Part Number	Description	Batch
1	D3278-1	Support	B27593A

FF 06.07-24

30

4.0	D32782	
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Comment: Qty.: 0.0000 Each(s)/Unit Total : 0.0000 Each(s)

SUPPORT

Pick:

Qty	Part Number	Description	Batch
1	D3278-2	Support	B27593B

FF 06.07-24

30

5.0	D32783	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3278-3	Spacer	B24098 (x29) B22971 (x1)

FF 06.07.24

30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:51:27 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 27593

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 MS20426AD37 RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s)

RIVET

Pick:

Qty Part Number Description

4 MS20426AD37 Rivet

Batch

M ~~16527~~ 16527

FF 06.07.24

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Rivet spacers with support as per Dwg D3278.

FF 06.07.24

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0 D22301 Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Mounting Lug

Pick: Packing Kit

Qty Part Number

2 D2230-1

Description

Mounting Lug

Batch

B 25553

FF 06.07.24

10.0 AN413A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

2 AN4-13A

Description

Bolt

Batch

B 101149

FF 06.07.24

11.0 AN960JD416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 120.0000 Each(s)

Washer

Pick: Packing Kit

Qty Part Number

4 AN960JD416


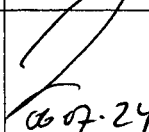
Description

Washer

Batch

M 101369

FF 06.07.24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06-07-24	6.0	Substitute -7 rivet for a -6. This time. -7 keep going crooked.					 06-07-24	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:  Date: 06/07/26

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 6/15/2006 1:51:28 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 27593

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation: Description :

12.0 MS21042L4 Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)  
Nut

Pick: Packing Kit

Qty Part Number Description  
2 MS21042L4 Nut

Batch

B 100743

FF 06.07.24

30

13.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble support as per Dwg D3278.  
\*\*\*DO NOT TIGHTEN BOLTS\*\*\*  
Identify as D3278-041

FF 06.07.24  
SAD 06.07.25

24

14.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: 57105

AP 06.07.25

16.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

S 06.07.06

Job Completion



AD 06.07.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

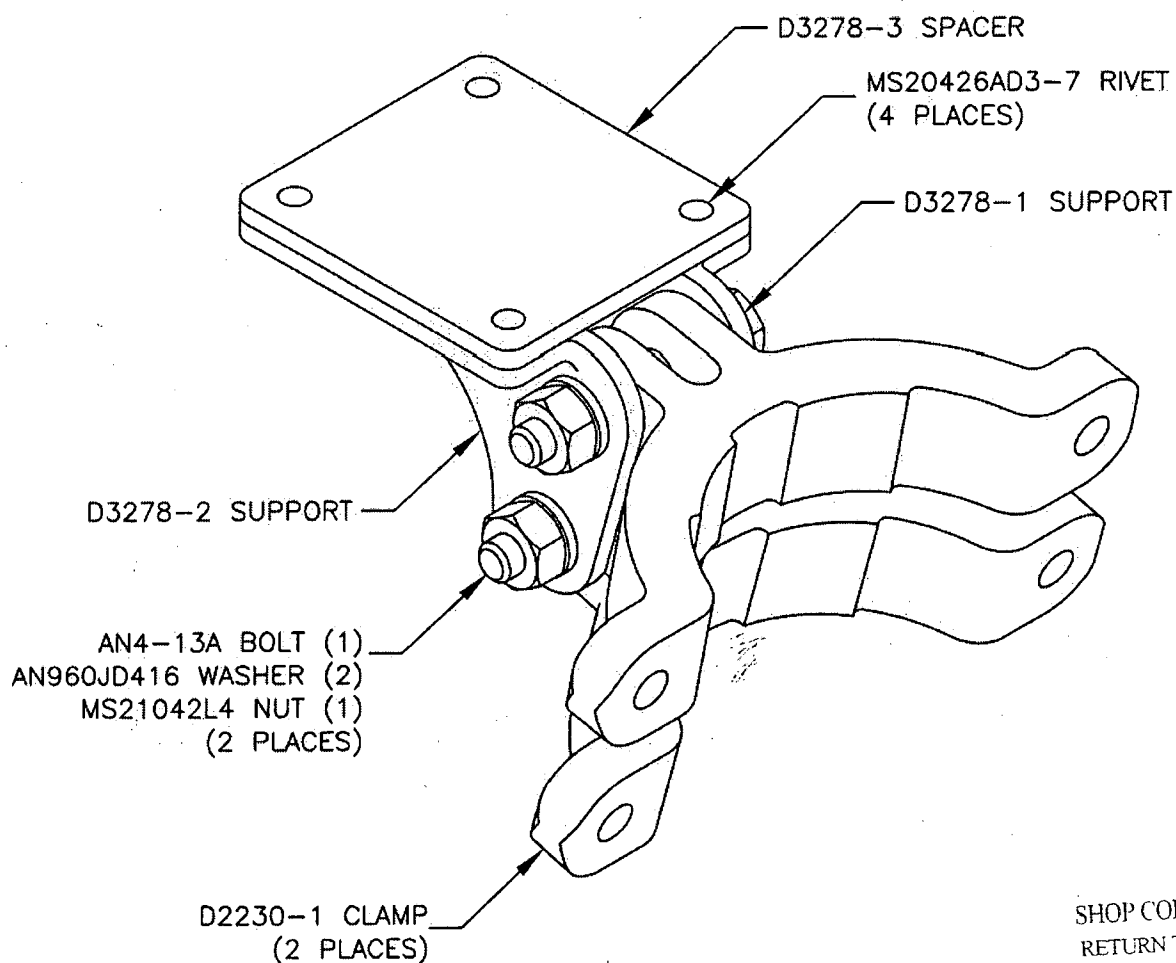
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



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CHECKED		APPROVED		DRAWING NO. D3278 REV. B SHEET 1 OF 3
DATE	05.03.31	TITLE	SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE		
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT		

RELEASED  
05.04.04

## D3278-041 SUPPORT ASSEMBLY



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NO. 27593

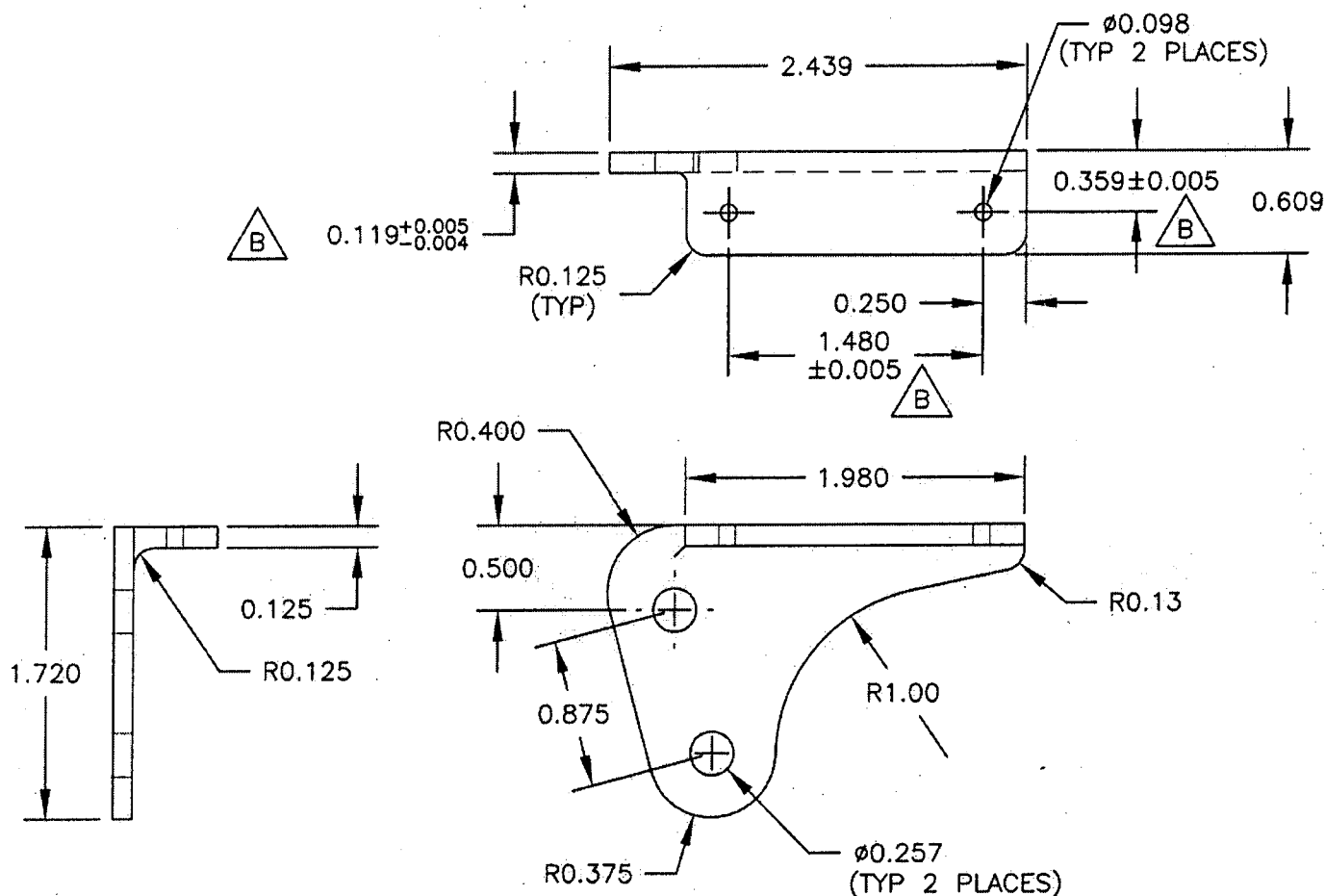
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DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 *[Signature]*

D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11)  
(REF DART SPEC. M6061T6B OR M6061T6S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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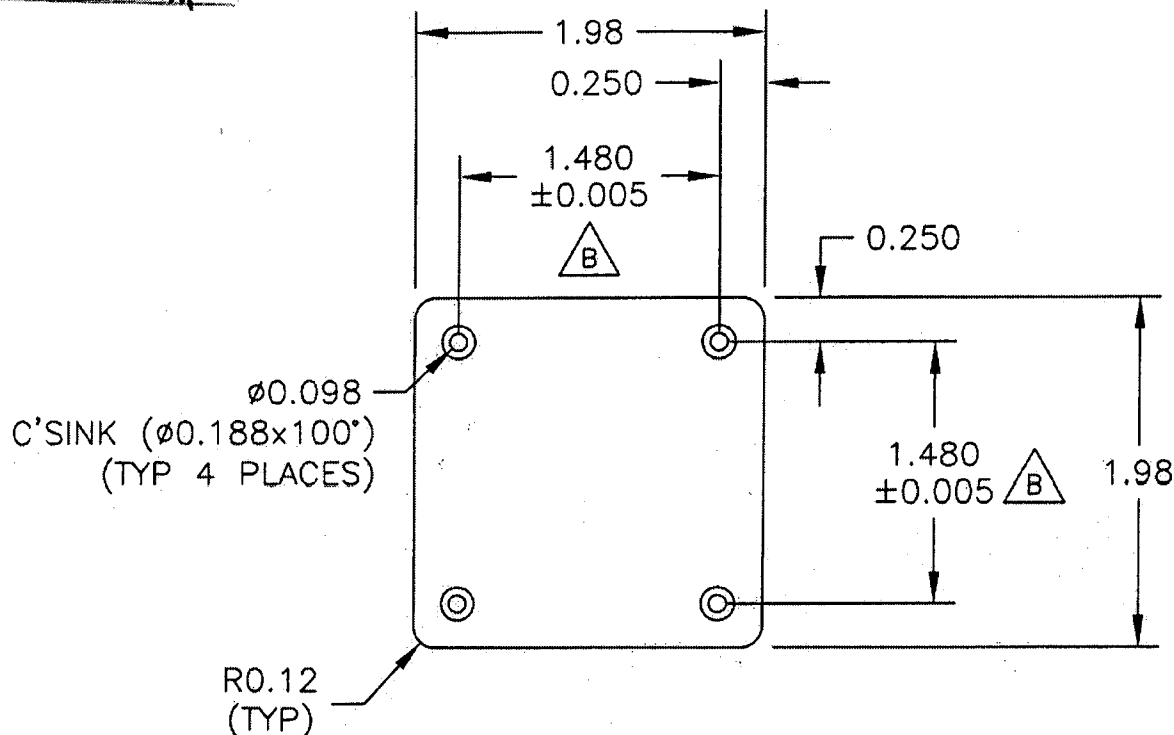


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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3278	REV. B SHEET 3 OF 3
DATE 05.03.31		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED

05.04.04 [Signature]

**D3278-3 SPACER**

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S  
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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